

Date: Monday, 20/04/2009 12:42:02 PM
User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : EXTRUSION 'I' BEAM TUBE 4"
Job Number : 46468	
Estimate Number : 10154	
P.O. Number :	Part Number : D25001190
This Issue : 20/04/2009 S.O. No. :	Drawing Number : D2500 UNDER REVIEW OK CP 09.05.11
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/03/2009 Type : SKIDTUBES	Drawing Revision : G
Previous Run : 40150	Material :
Written By :	Due Date : 27/03/2009 Qty: 41 Um: Each
Checked & Approved By : <u>MF 09-05-11</u>	
Comment : Est: G 02.09.05 Added DSK 066 KJ/RF est H 07.07.06 rev G dwg EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 8388

- a) Extrude as per Dwg D2500
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 38 ksi
- e) Minimum elongation = 8%
- f) Order at 190" long
- g) Bon L Canada Inc. tool # 897105
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

C209/04/20 (45)

2.0	D25001190P	Ext'n - 'I' Beam Tube 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 41.0000 Each(s)
EXTRUSION 'I' BEAM TUBE 4"

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure material certification is attached

C29/5/8 (50)

Date: Monday, 20/04/2009 12:42:02 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EXTRUSION "I" BEAM TUBE 4"

Job Number: 46468

Part Number: D25001190

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions per Dwg D2500

Check Pull test per Dwg D2500 for compliance page attached.

Check hardness with Webster tester

09/05/08

comba
(150)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

fm 09-05-11 (B)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/11 JA

Job Completion



mf 09-05-11



DESIGN #	DRAWN BY P#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2500	REV. G SHEET 1 OF 3
DATE 07.04.17		TITLE EXTRUSION	SCALE NTS
A	96.03.19	NEW ISSUE	
B	96.03.24	CHANGE INTERNAL WEB	
C	96.04.26	ADD D2500-3 WEB	
D	96.10.07	ADD MATERIAL PROPERTIES	
E	96.10.24	CHANGE MATERIAL TEMPER	
F	97.09.29	CHANGE MAT. TO 6061-T6	
G	07.04.17	ADD NOTES 3,5,6	

RELEASED
07.04.28 #

UNDER REVIEW

08.04.02 UP
FOR REV. H

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM TENSILE YIELD STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO
ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY
TO ENSURE THAT THE BATCH MEETS THE ABOVE
MINIMUM MECHANICAL PROPERTIES

2. BREAK ALL SHARP CORNERS 0.010 MAX
3. ALL DIMENSIONS ARE IN INCHES
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED.
5. FOR D2500-1 PART NUMBER IS D2500-1-XXX WHERE XXX IS
CUT LENGTH (EX. D2500-1-190 IS 190" LONG)
D2500-1 EXTRUSION MANUFACTURED FROM:
- A) BON L DIE # 897015 -> PREFERRED
 - B) CARADON MIDEAST DIE # PAH-28030
 - C) CARADON MTL DIE # MH-18868
- 46468
6. FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS
CUT LENGTH IN INCHES (EX. D2500-3-100 IS 100" LONG)
D2500-3 EXTRUSION MANUFACTURED FROM:
- A) CARADON INDALEX DIE # MS-18867

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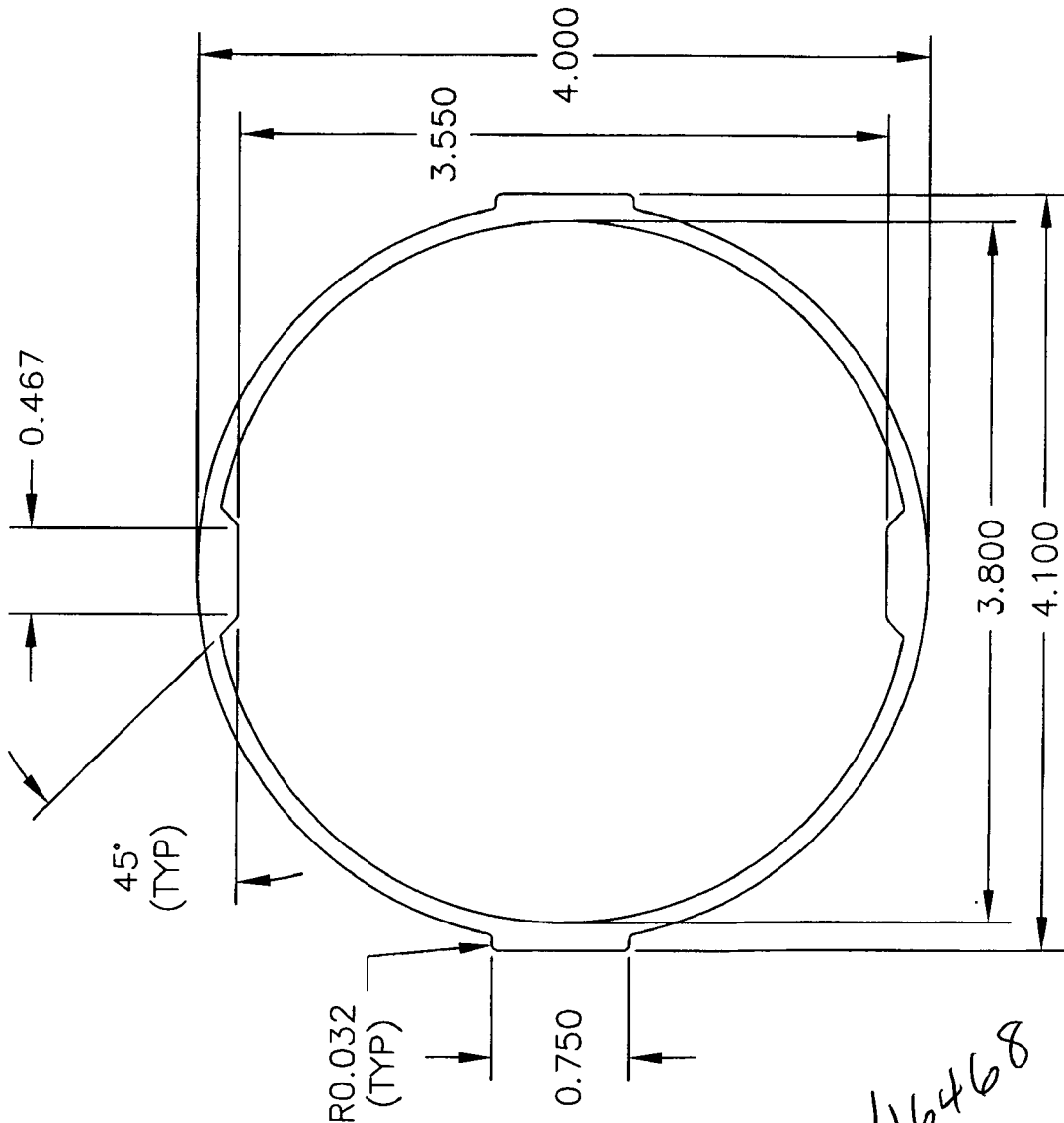
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DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2500	REV. G SHEET 2 OF 3
DATE 07.04.17		TITLE EXTRUSION	SCALE 1:1

RELEASED
07.06.18-#

UNDER REVIEW
08.04.02 UP
FOR REV. H



D2500-1

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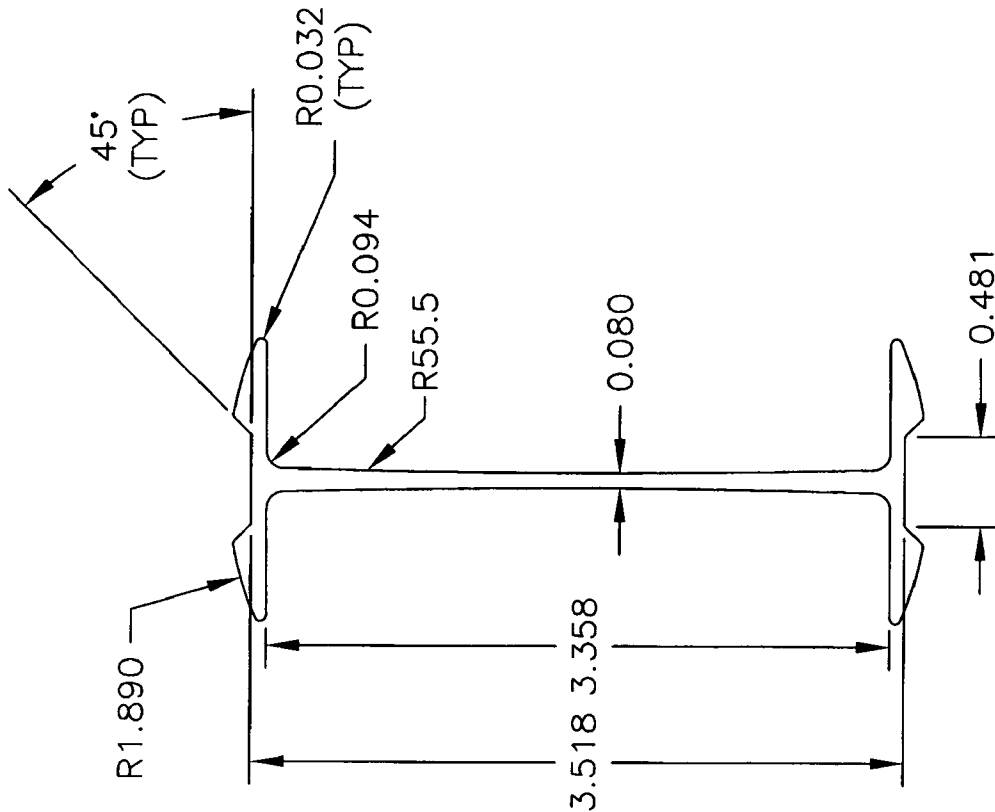
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DESIGN <i>[Signature]</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2500	REV. G SHEET 3 OF 3
DATE 07.04.17		TITLE EXTRUSION	SCALE 1:1

RELEASED
07.06.28 *[Signature]*

UNDER REVIEW
08.04.02 *[Signature]*
FOR REV. H



D2500-3

46468

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ACCT# 00046024

INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

SHIPPING MANIFEST

MANIFEST DATE	05-07-09
MANIFEST NUMBER	658997
SALES ORDER NUMBER	46485

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCECREDIT REP
HAMBROOK, PAU
905-508-3250

SALES REP

SHIP TO
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CNSOLD TO / PURCHASER
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CN

TERMS / FREIGHT

O / P

PHONE 613-632-5200

PHONE 613-632-5200

LOCATION	TRAILER NUMBER	SALESMAN	FIELD SALES REP	CUST SERVICE REP
PIC	57382	59358	Kutter A 450-435-6551	Burton D 905-427-2227
BILL OF LADING NUMBER				08392211

CUSTOMER ID	ORDER DATE	CUSTOMER PO NUMBER
46024	04/09/09	8388 REPLACEM

ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER	ALLOY & TEMPER	FINISH DESCRIPTION	NBR OF PKGS	THIS SHIPMENT		UNIT	QUANTITY DUE	
				CUSTOMER PART NUMBER	LENGTH	FABRICATION DESCRIPTION		GROSS POUNDS	NET QUANTITY			
					CUTTING TOLERANCE	SHIPPING TOLERANCE						
01	42	KG M PC	0 0 0	DAA-897105-2 D2500-1-190	6061 /T6 190 " +5/16 " -0 "	MILL CERTIFICATE OF COMP (+015-015,0048-0035)	3	615	598 241.30 50	KG M PC	0 0 0	
This is a replacement order. Refer to Return # 3 8127.												
LOT/TKT DETAIL:												
							1	55	50		4 PC	
							1	280	274		23 PC	
							1	280	274		23 PC	
							3	615	598 241.30 50	KG M PC		
							TOTALS					

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.

No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE1

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.

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PAGE 1

DATE OF DELIVERY

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

Cert Date	Cert No	Sales Order	Page
05/07/09	190930	46485	1
Customer	P.O. No	Lot	Date
8388 REPLACEMENT	08392211	46485010	5/07/09

Sold To	Ship To
48024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	48024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Customer Part
1.000	DAA-897105-2	190" Mill 6061 T6	D2500-1-190
Gross Weight	615 KGS		
Net Qty	598 KG	50 PC	241 M 3 PKG
Specification	Die Desc		
AMS-QQ-A-200/8 & ASTM B221-08			

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift HREW
1	301.2 / 43.7	276.4 / 40.1	9.6	.0	93
2	295.8 / 42.9	269.0 / 39.0	10.0	.0	93

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI
.64	.37	.24	.10	.88	.09	.05	.02

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

Conchita Ko, QA Manager Signature Aluminum Canada Inc

Signature
05/07/09

Conchita Ko.

DART

Purchase Order

Date Mar 12, 2009	Page 1
Purchase Order Number PO00008388	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAXED

Vendor Address:

Signature Aluminum
1850 Clements Road
Pickering, ON L1W 3R8
Phone (800) 563-1079
Fax (800) 565-8339

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference REPLACEMENT ORDER	Contact	Vendor Number VC-BON001	PO Date Mar 12, 2009	Terms N30	Ship Via yours	Expected Arrival Mar 27, 2009
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april 25

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
45.0000	D25001190P	Ext'n -1' Beam Tube 4" Comments: EXTRUDE AS PER DWG D2500 REV. G MATERIAL: 6061-T6 (QQ-A-200/8) MINIMUM YIELD TENSILE STRENGTH = 35 KSI MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI MINIMUM ELONGATION = 8% 190" LONG BON L CANADA INC. TOOL # 897105 TO BE PACKED PER DSK 066 PULL TEST TO ASTM STANDARD B221 REQUIRED B46468	27/03/2009	No	71.506000	Each	3,217.77

New 50
P. 9/5/12

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Comments:

Tax Summary:

GST 160.89
GSTME 0.00
GSTND 0.00

Less:

included tax

0.00

Subtotal

3,217.77

Total tax

160.89

Total purchase order in

CAD Dollars

3,378.66

Entered By: CL CLAVOIE

Approved By: W